









**Work Order ID 74317**

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Wednesday, September 28, 2011 1:13:34 PM

Item ID: D3913-15 Accept  Setup Start   
Revision ID: Stop   
Item Name: Wide Handle Plate  
Start Date: 9/28/2011 Start Qty: 3.00  Cust Item ID:  
Required Date: 10/4/2011 Req'd Qty: 3.00  Customer:  
Reference:

Approvals: Process Plan: MLJ  Date: 11/08/28 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304.172

Cut as per dwg D3913

Prog Rev: ADwg Rev: A

Deburr as required

B11-10-63

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries





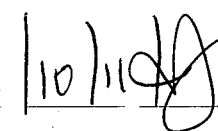
# Work Order ID 74317

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Item ID:	D3913-15	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wide Handle Plate					
Start Date:	9/28/2011	Start Qty:	3.00		Cust Item ID:	
Required Date:	10/4/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		8.11.10/06		(83)			
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u>  Memo	0.00 0.00				(X3)	11-10-6		
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							11/10/11  mc 11-10-6

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Wednesday, September 28, 2011 1:13:55 PM

Page 1

Work Order ID: 74317

Parent Item: D3913-15

Parent Item Name: Wide Handle Plate





Start Date: 9/28/2011

Required Date: 10/4/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	144.4000	0.1068	0.337263			
304/316 0.125 Sheet													

1311-10-6

Location

Loc Qty

Loc Code

MAT020

144.4

117494

16.4

119006

64

119048

64

117494

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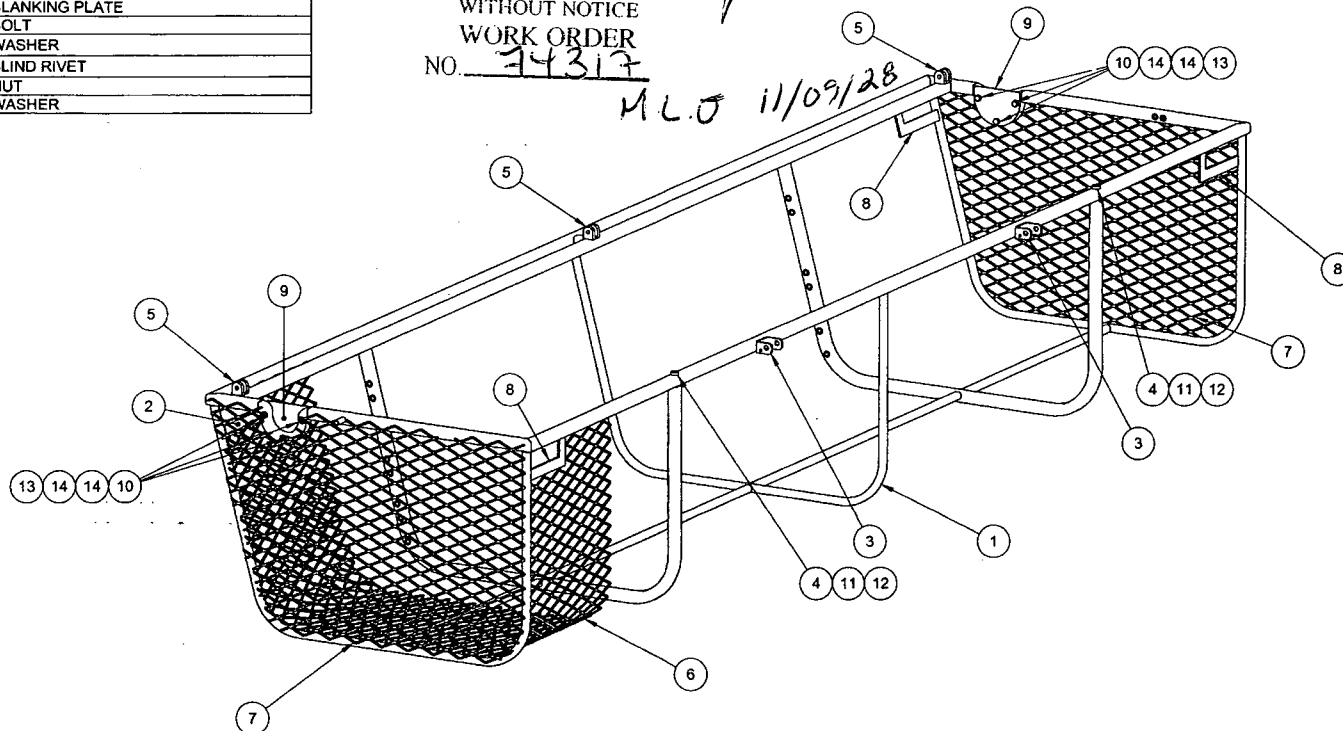
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74317

M.L.O 11/09/28



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2010-03-22  
WJP

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
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MFG. APPR.		D3913	SHEET 1 OF 6
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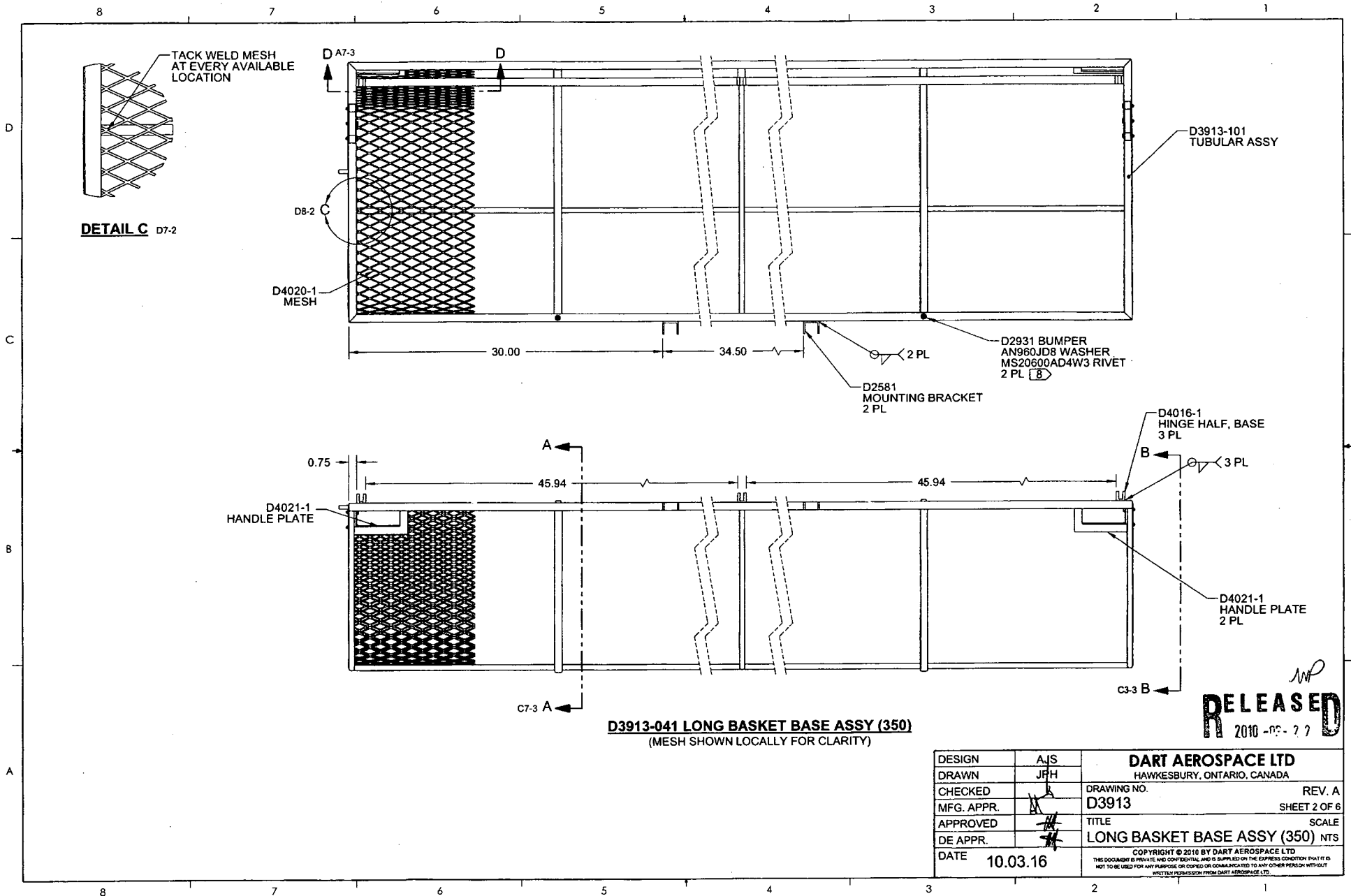
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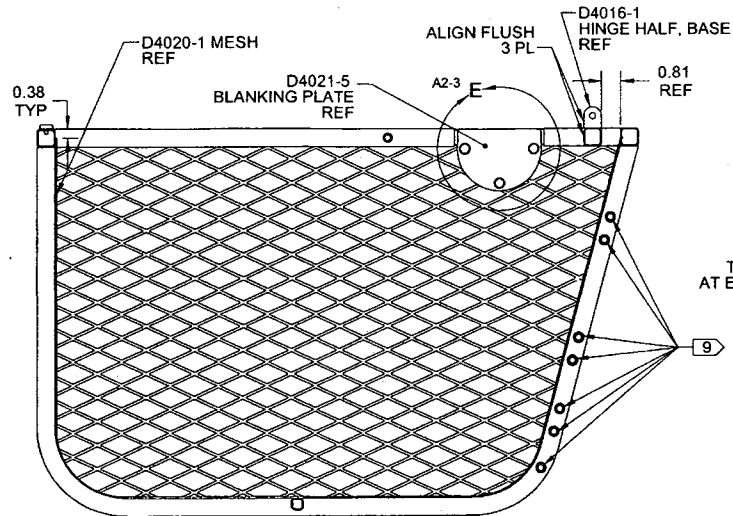
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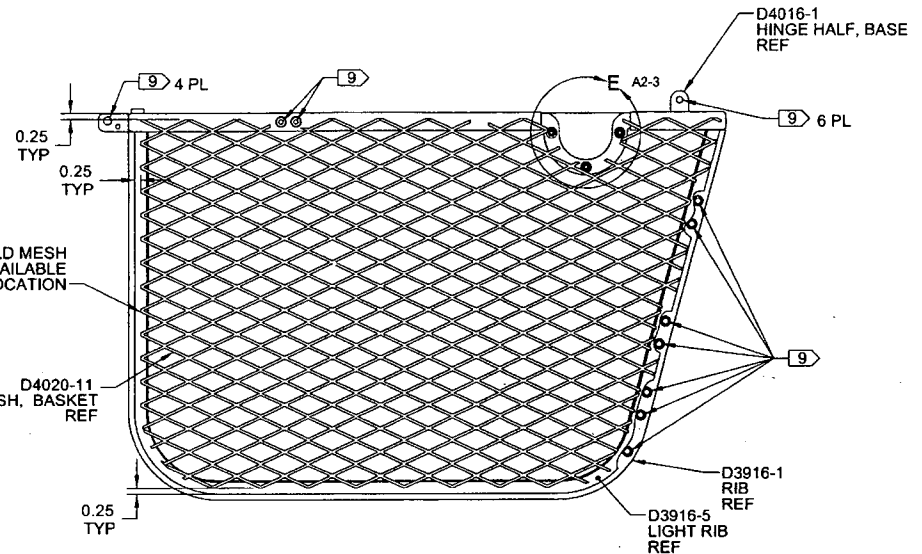
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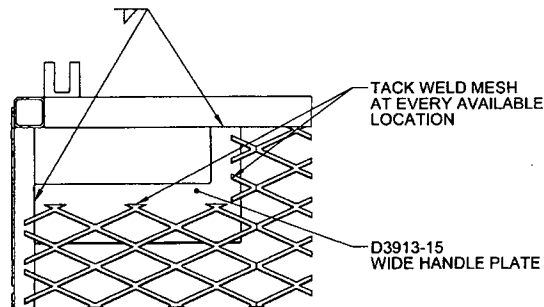
74317



**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES





8 D4021-5  
BLANKING PLATE

8 AN3-10A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
3 PL

TRIM MESH LOCALLY  
Ø0.50 - Ø0.60  
TO CLEAR FASTENERS

**DETAIL E** D2-3  
D6-3

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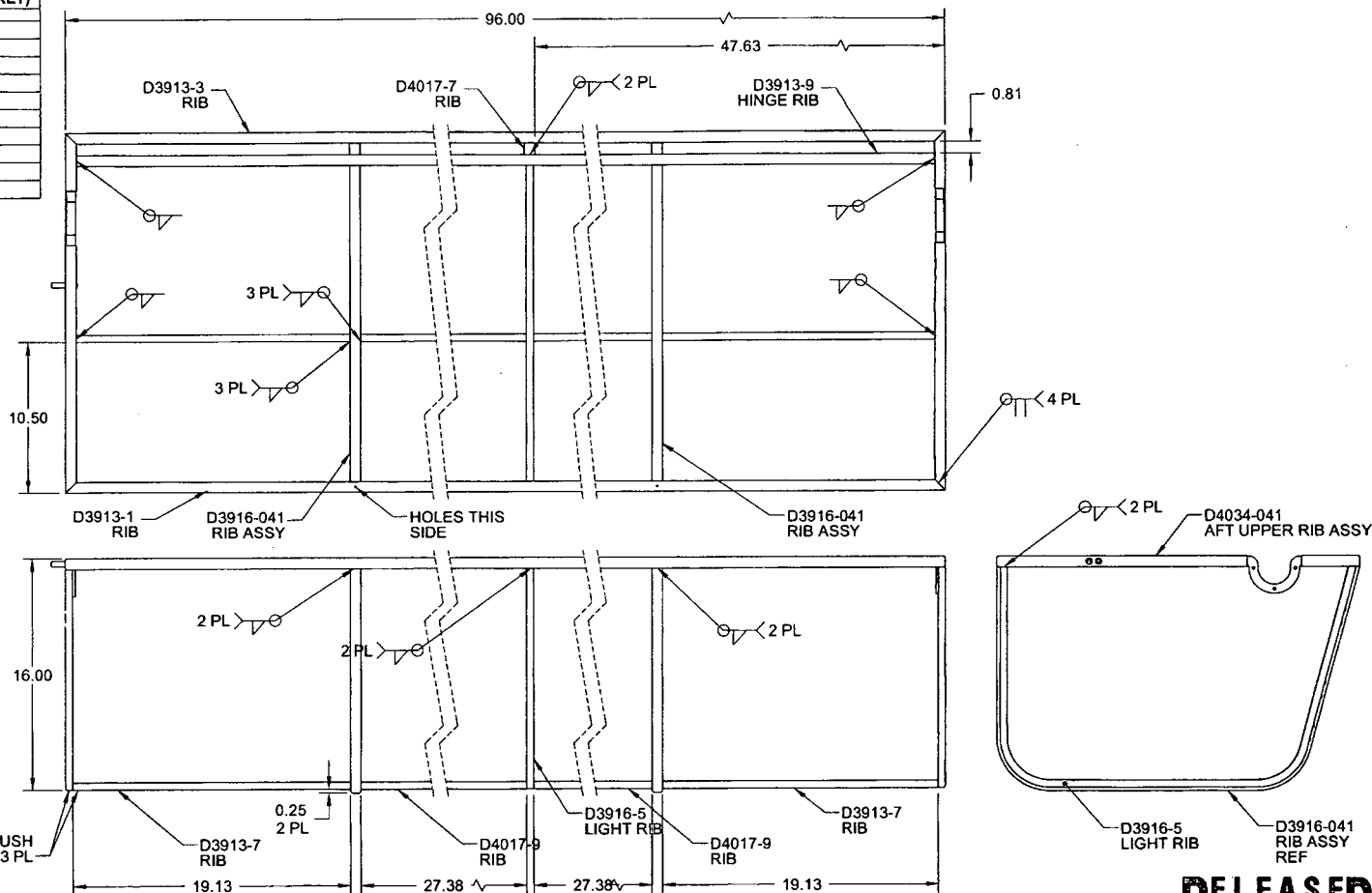
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

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MFG. APPR.	<del>JS</del>	D3913	SHEET 4 OF 6
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	LONG BASKET BASE ASSY (350) NTS	
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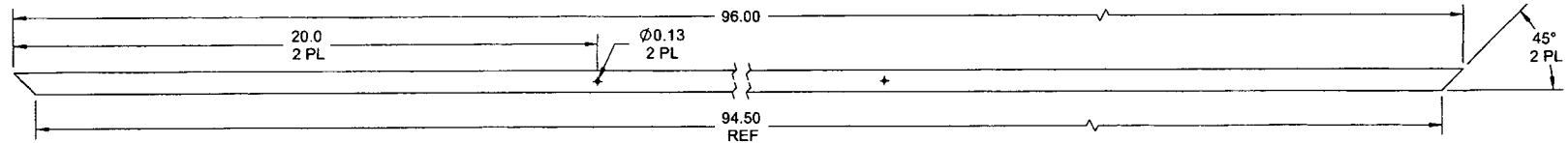
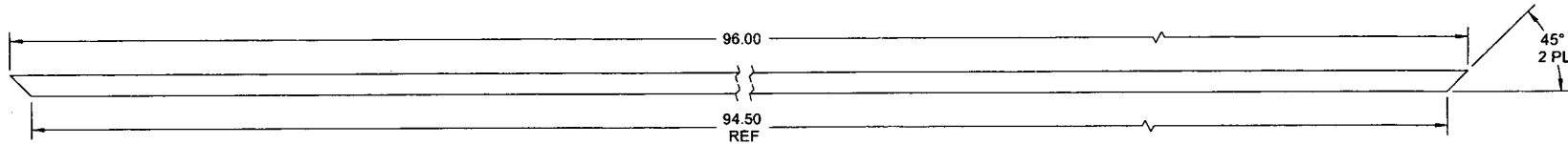
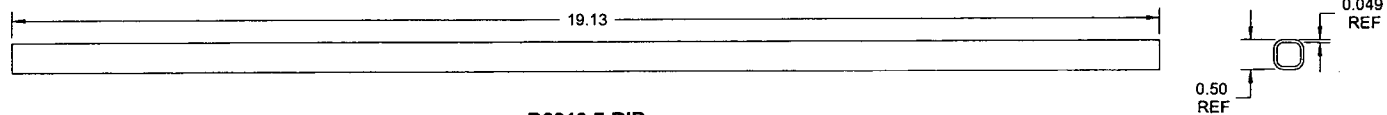
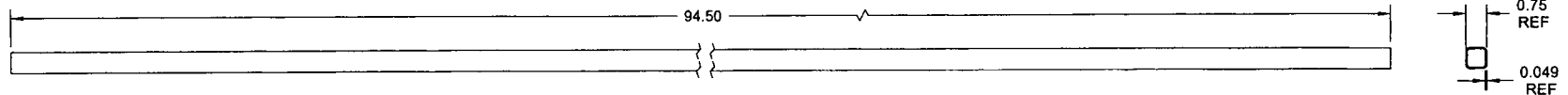
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**D3913-1 RIB****D3913-3 RIB****D3913-7 RIB****D3913-9 HINGE RIB****NOTES:**

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: SEE ASSEMBLED WEIGHTS

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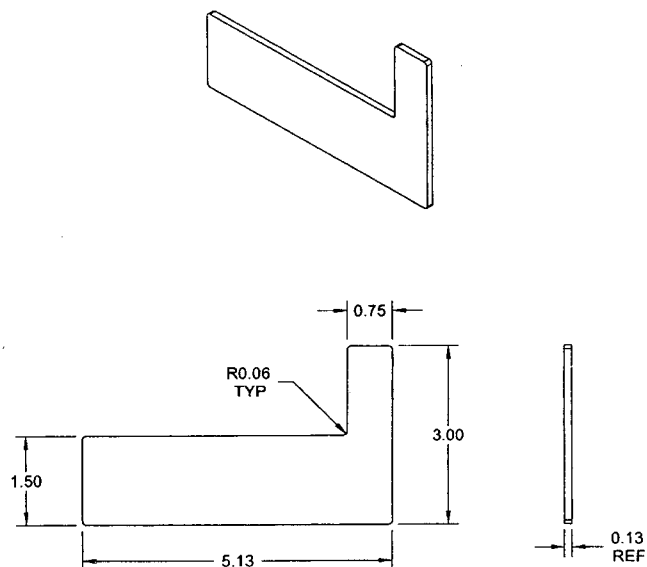
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**D3913-15 WIDE HANDLE PLATE****NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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